

Work Order ID 152620

Tuesday, November 01, 2016 1:35:11 PM

152620

Page 1

Item ID: D6102-013 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet
Start Date: 11/3/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 11/17/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: NOV 01 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6102	Rev D								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>34163</u> a) Description: Aluminum Billetb) 7.000" x 6.500" x 2.000" thickc) Tolerance on all dimensions is +0.06/0.00d) Grain direction along 6.500" lengthe) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)Material release certifi								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.07							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check certification to Dwg D6102 for compliance								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 152620***152620***

Page 2

Tuesday, November 01, 2016 1:35:11 PM

Item ID: D6102-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle Billet

Start Date: 11/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: MAT046

0.00

130

Packaging

Memo

0.03

Packaging

LOCATION: MAT046

200DAS
14
9-89

11/11/27

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.33

Quality Control

DAS
21
9-89

NOV 28 2016

DAS
21
9-89

NOV 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
30-01 31-01 30-02								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, November 01, 2016 1:35:15 PM

Page 1

Work Order ID: 152620

152620

Parent Item: D6102-013

D6102-013

Parent Item Name: Saddle Billet

Start Date: 11/3/2016

Required Date: 11/17/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6102-013P

Purchased

No

110

Each

0.0000

1

20

D6102-013P

6061-T6 7.0X6.5X2.0

20x SP/6-11-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

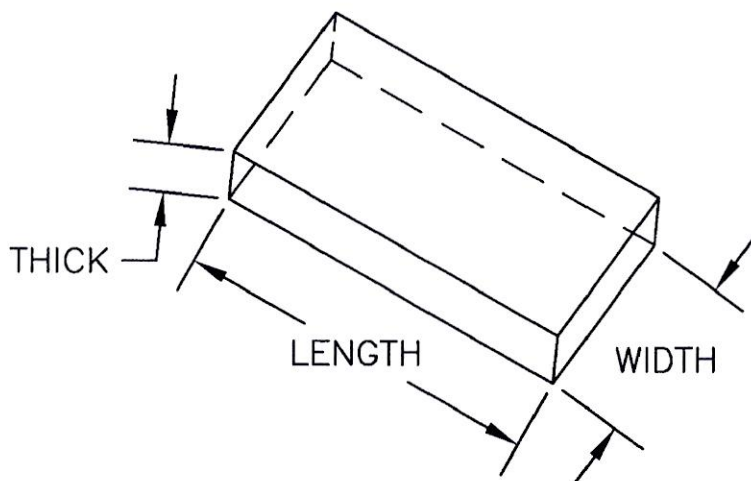
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					



DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152620005
16-11-01
RELEASED
06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO34163

Purchase Order Date 11/3/2016
PO Print Date 11/3/2016

Page Number 2 of 3

Order From :

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Yours ppd

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

D6102-013P

6061-T6 7.0X6.5X2.0

11/16/2016
Yes
11/16/2016

AS PER DWG D6102 REV. D
B152620
SIZE: 7.000" X 6.500" X 2.00" THICK
GRAIN DIRECTION ALONG 6.500"
MATERIAL 6061-T6/T6511 QQ-A-250/11
TOLERANCE AS PER QUOTE +.030"/-.000

20.00
Each

Line Total: \$643.00

\$31.65 \$633.00

Spoke 11-25

4 D6104-003P

17-4 SS Roundbar 3.25"Od

11/16/2016
Yes
11/16/2016

AS PER DWG D6104 REV. B
B152621
SIZE: 3.25" X 3.80" LONG
MATERIAL: 17-4 PH AS PER AMS 5643 OR AISI 630

10.00
Each

Line Total: \$633.00

\$26.70 \$267.00

NOV 08 2016

DAS
26
9-89

Line Total: \$267.00

Note:

11/3/2016

INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3123104

Ship From: A. M. CASTLE & CO. 14001 ORANGE AVENUE PARAMOUNT, CA 90723 USA		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 10-NOV-16	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier ABF		BOL No 3123104-2	

Shipment Details	Final Destination Branch - TOR
-------------------------	---------------------------------------

Order No	Line No	Item No	Description	
4556094	3	8641 MO	2.0000.PL.6061.T651.ALUMINUM.48.5000.144.5000 CUT RECTANGLE TO 7 IN (+.0310/- .0000 IN (USE HT # 182396B2 ONLY)) X 6.5 IN (+.0310/- .0000 IN (GRAIN TO RUN ALONG 6.5")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/11	
Purchase Order No	Part Number		Ordered Qty	Invoice Qty
34163	YOUR ITEM NUMBER: D6102-013		20.00 PCS	20.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
----------------	--

Delivery No. 120655575	Mill	Heat Number 	Mech Id	PCS 20	Width (IN)	Length (IN)	Shipped Qty(LBS) 182.2848
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These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 10-NOV-2016 03:31:41 PM

INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.			
Reviewed by Authorized Castle Metals Representative:		Date:	Name: <i>JA</i>



SD/6 11-25

SHIP TO: A M CASTLE & CO 14001 ORANGE AVE P.O. BOX 1402 PARAMOUNT, CA 90723
SOLD TO: AM CASTLE & CO- SOLD TO 1420 KENSINGTON RD SUITE 220 OAK BROOK, IL 60523

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4432662

CUSTOMER PO NUMBER: 389335-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 8641	SHIP RUN/LOAD: 103681/8	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1217412-1	SHIP DATE: 11-SEP-2016	ALLOY: 6061	CLAD: BARE	TEMPER: T651
PRODUCT DESCRIPTION: KaiserSelect Precision Plate				
WEIGHT SHIPPED: 5592 LB	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2062388	GAUGE: 2.0000 IN (50.8000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)
			LENGTH: 144.500 IN (3670.3 MM)	

MHU 2030481: LOT 188930B2: 2 pieces;
MHU 2030510: LOT 182396B2: 2 pieces;

Certified Specifications

AMS 4027/RevN
EN 10204-3.1/Rev2004

ASME SB 209/Rev2010

ASTM B 209/Rev14

Test Code: 1511

Lot: 182396B2 Cast 590

Drop 90

Test Results

Ingot 5

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	49.1 : 49.2 (339 : 339)	43.9 : 44.6 (303 : 308)	14.1 : 14.2

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.73	0.5	0.33	0.06	1.0	0.20	0.10	0.02	0.01	0.00	TOT 0.06
Lot: 188930B2	Cast 611	Drop 28			Ingot 5						Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	48.4 : 48.9 (334 : 337)	43.9 : 44.5 (303 : 307)	13.9 : 14.2

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.77	0.5	0.33	0.05	1.1	0.18	0.07	0.02	0.01	0.00	TOT 0.06



KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4432662

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN(wt%)	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC A96061-161 R 3

TEST NOTES

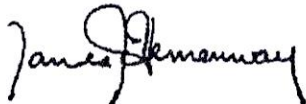
6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS
4027 also meets applicable requirements of cancelled
specification AMS-QQ-A-250/11, Rev. A.

CERTIFICATION

Kaiser Aluminum, Trentwood Works, is ISO 9001, AS9100, and ISO 14001 certified, and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein.
- * All test equipment and measuring devices are calibrated and certified in accordance applicable specifications. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. Reported elongation values have been measured as elongation at fracture.
- * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
- * has been thermally processed in compliance with AMS 2772, where applicable.
- * is mercury free, within the limits of detection of ASTM E1215 (< 1ppm).
- * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- * is in compliance with European Chemical Agency, ECHA, REACH regulations, IEC) No 1907/2006, and Kaiser regularly monitors these regulations for updates.
- * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
- * is free of weld repair.
- * meets the reporting requirements of EN10204, Type 3.1.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



JAMES HEMENWAY, TECHNICAL PROCESS MANAGER

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: DL102-013
 DATE: 16/11/27

PO / BATCH NO.: 34163/152620

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 20
 QUANTITY INSPECTED: 20
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 2.00
 THICKNESS RECEIVED: 2.030
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒	
CORRECT FINISH	☒ N	
CORROSION	Y ☒	
CORRECT GRAIN DIRECTION	☒ N	
CORRECT MATERIAL	☒ N	<u>6061T6</u>
CORRECT THICKNESS	☒ N	<u>2.030</u>
PHOTO REQUIRED	Y ☒	
CORRECT MATERIAL	☒ N	<u>AMS-QQ-A-250/11</u>
CORRECT REF # TO LINK CERT	☒ N	<u>HEAT # 182396 B2</u>
CORRECT MATERIAL IDENTIFICATION	☒ N	<u>DL102-013</u>
CORRECT M# ON THE MATERIAL	☒ N	<u>B152620</u>
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>14</u> <u>9-89</u> DATE: <u>16/11/27</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in